

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014800**Date Inspected:** 15-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 8AW-8BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 045246 performing Shielded Metal Arc Welding process for weld 044 located on PCMK SEG043*. ZPMC QC Mr. Shi Lei monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F)-FCM-Repair-1. Critical weld repair report identified as B-CWR-1613.

ULTRASONIC INSPECTION**OBG SEGMENT 8AW, 7DE, 8AE, 8CE**

ZPMC NWIT No: 005981

This Q.A Inspector performed Ultrasonic testing of approximately 10% of the area previously tested and accepted

WELDING INSPECTION REPORT

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by ZPMC Quality control personnel. This QA Inspector generated a (U.T) report for this date. The members are identified as the X8E and X3S.

Weld Designations are as follows.

SEG043E-013, 022, 031; SSD22-PP62.5-168; SEG044D-027; SEG044E-074, 083, 018; SEG048S-109, 118; SEG040E-109, 118, 091.

OBG SEGMENT 8BW- 8CE

ZPMC NWIT No: 005984

This Q.A Inspector performed Ultrasonic testing of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (U.T) report for this date. The members are identified as the OBG segment 8BW and 8CW. Weld Designations are as follows.

SEG045B-006, 024; EP074-001-014; DP653-001-021; SP446-001-033; SP487-001-063; SP725-001-048; SP765-001-044, 046; BP041-001-022, 026, 028; SP157-001-050; BP095-001-024; SP130-001-044; SP103-001-057, 063; SP435-001-033; EP063-001-014; DP645-001-019.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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